Work Orde December-17-12	er ID 94412 3:09:51 PM		*944	112*		()	Page 1
Revision ID:	D2348 Wearplate	50	Accept	*N900040	1100*	Setup Start Stop	*NS1*
Start Date: Required Date: Reference:	17/12/2012 Start Qty: 02/01/2013 Req'd Qty:	/ / / /		Cust Item ID: Customer:		·	"NS7"
Approvals:	Process Plan: MUS			Date:	- 	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID Tool #	Plan Accept		Reject Insp.
Draw Nbr	Revision Nbr				Code Qty	Qty 1	Number Stamp
D2348	Rev C					* *	•
*100 *100* Waterjet FLOW CNC Waterjet	Dwg Prog		0.00		80	&	JM13-1.25
*110 *110* QC Quality Control	QC2- Inspect par	rts off machine FAI/FAIB	0.00		80	0 0	Jm 13-1-25
120 *120* QC Quality Control	QC8- Inspect par		0.00			13-01-3)3 (DA)

被職務

NCR:	Yes	/	No

											DQA:	Date:		
NCR:	Yes	/ No					WORK ORDER NON-C	100	NFOR	MANCE / UPDATE			7	
											QA Closed:	Date:		
Nork Ord	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part NCR							Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Small Fab noforming Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root	_				Des	crip	tion of work order update	Ī	nitial	Action	Sign &			
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector	
oc/Data quip/Tooling perator faterial etup ther rocess upplier raining napproved									·					
							FA	AUL	T CATE	GORY				
Land	ng (7					General	_	1	_	_		- -	
		Bending Centre No Cracks Crushed/O Cuffs Heat Trea	Crimped. t		O/S		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Instruct Mainte Mislabe	ior Incomplete tions Incomplete/Unclear enance eled	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes					Misread Power Loss/Surge Other					Other				
	-	Torque W			,		Drill Holes	\vdash	Offset	Calibration				
	\vdash	•			'		Drawing Finish	\vdash	4					
	Turning Sequence Finish					า แบอน		Out of Sequence						

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-17-12 3:09:51 PM

Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	D2348 Wearplate 17/12/2012 : 02/01/2013	Start Qty: 20.00 Req'd Qty: 20.00	~*20* *20*	Accept	*N900 Cust Item Customer:	ID:	100)* s	Setup Start Stop	11/2		
Approvals:	Process Pla	an: Date	»:	Tooling:	D	ate:		R	Run Start	*N	R1*	
	QC:	Date	:	SPC (Y/N):	D	ate:			Stop	*N	R2*	
Sequence ID/ Work Center I 150 *150* Outsource4 Outsource process		Operation Description Outsource process-Anodize per C Memo Issue P/O: / 8 Black Anodize per D Ensure Certificate of	9 wg D2348	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty		Reject Number	Insp. Stamp	
*160 *160* Packaging Packaging	•	Receive & Inspect for Damage & Memo Ensure certificate of		0.00 0.00 hed					fy] 3/2/4	,(\$0	
170 QC Quality Control		QC5- Inspect part completeness to Memo INSPECT CERTS	step on W/O	0.00 SAS 15. 12. 24				80				

								DQA:	Date:			
NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UPDATE	•		9		
							•	QA Closed:	Date:			
Work Orde	m.				DISPOSITION		AC	GAINST DEPARTMENT	/PROCESS			
work Orde	·				Rework	1	Skid-tube Cro	osstube	Water Jet	Engineering		
Part N	0				Scrap	1	<u> </u>	<u> </u>	d. Eng. Coor.	Quality		
Faitin	U	 -		 	Use-as-is	4 I	~ 	 	re/Packaging	Other		
NCR N	n				Work Order Update	"""	· H	nposite	Supplier			
,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	··				Work order opudie	' [20186 100			J LJ		
Root				Descri	ption of work order update	Initial	Action	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Description	n Date	Verification	QC Inspector		
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					F.	AULT CATE	GORY					
Landin	g Gear			_	General							
	Bending				Bend	Grain		Ovalized		Pressure/Forced		
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardw	are	Over/Under	tolerance	Temperature/Cure		
_	Cracks		•		Broken/Damaged	—	tion Incomplete	Part Incorre		Weld		
	Crushed/	Crimped.	•	<u> </u>	Burrs	Instruc	tions Incomplete/Unclea	r Part Lost/Mi	issing	Wrong Stock Pulled		
	Cuffs				Contamination	Maint	enance	Part Moved				
Heat Treat					Countersink	Mislab	eled	Positioned V	Positioned Wrong			

Mislabeled Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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December-17-12 3:09:51 PM

Page 3

Revision ID: Item Name:	D2348 Wearplate 17/12/2012 02/01/2013	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*	Accept	*N90002 Cust Item ID: Customer:	1010	^* Setu	p Start Stop	111121
Approvals:		n:	Date:	Tooling: SPC (Y/N):			Run	Start Stop	"NR1"
Sequence ID/ Work Center ID 180 *180* Small Fab Small Fab 190 *190* QC Quality Control		Operation Description Small Fab Memo Install Insert	as per Dwg D2348 teness to step on W/O	Set Up/ Run Hours 0.00 0.00 0.00 15 0.00 3.2-5	Tool ID To	ol# Plan Code			Reject Insp. Number Stamp
*200 *200* Packaging Packaging		Identify as per dwg & Stor	ck Location: Tw9	0.00			Sex		B-00-S

											DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	100	NFORM	MANCE / UPDATE			*
	-								,		QA Closed:	Date:	
Nork Ord	er:						DISPOSITION			AGAINST D	EPARTMENT,	/PROCESS	
Part NCR	No.						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite	→	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
· · · · · ·							Work Order opdate	1		composite		3dppilei [
Root					Des	cri	otion of work order update		nitial	Action	Sign &		
Cause		Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining		•											
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Landi	ng (Sear					General				_		
		Bending Centre No Cracks Crushed/C Cuffs		ntric to (O/S		Bend BOM/Route Broken/Damaged Burrs Contamination		1	ion Incomplete ioris Incomplete/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Heat Trea	t				Countersink	П	Mislabe	}	Positioned V	Vrong	
		Inspection	Strip in	Tube	Ì		Cut Too Short	Г	Misread)	Power Loss/		Other
	Ripples in Bend Drill Holes						Offset	L	I '		.1		
		Torque W	aves in E	xtrusio	n		Drawing	Г	Out of C	Calibration			
	Turning Sequence Finish				Finish		Out of S	Sequence					

Outside Dimensions

Wave/Twist in Tube

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December-17-12 3:09:51 PM

Item ID: D2348 Accept *N900040100* Setup Start **Revision ID:** Item Name: Wearplate **Start Date:** 17/12/2012 **Start Qty: 20.00 Cust Item ID: Required Date: 02/01/2013** Rea'd Otv: 20.00 **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop OC: Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 210 QC21- Final Inspection - Work Order Release 0.00 *210* NUF 2-06 0.00 Memo Quality Control

										DQA:	Date:	
NCR: Y	es /	/ No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:	*
Work Orde	r:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo					Rework Scrap Use-as-is		Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo		 .	in	<u> </u>	Work Order Update	Inch	Large Fab	Composite	Nec/3tol	Supplier	
Root					Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												,
Operator												
Material												
Setup												
Other				,								

	FAULT CATEGORY										
Landing	Gear	General		_							
	Bending	Bend		Grain		Ovalized	Pressure/Forced				
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure				
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld				
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled				
	Cuffs	Contamination		Maintenance		Part Moved	_				
	Heat Treat	Countersink		Mislabeled		Positioned Wrong					
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other				
	Ripples in Bend	Drill Holes		Offset							
	Torque Waves in Extrusion	Drawing		Out of Calibration							
	Turning Sequence	Finish		Out of Sequence							
	Wave/Twist in Tube	Folio		Outside Dimensions			•				

Process
Supplier
Training
Unapproved

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Picklist Print

December-17-12 3:09:55 PM

Work Order ID: 94412

94412

Parent Item:

D2348

D2348

Parent Item Name: Wearplate

Start Date: 17/12/2012

Required Date: 02/01/2013

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev A IPP Rev:B

Removed from 9 Digit 05-12-05 JLM

Now on Waterjet 06-07-03

Manufactured No

JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M6061T6S.063		Purchased	No			100	sf	418.0000	0.0198	_ 0.41684 2		··		
M6061T6	S 063								**	2.0		_	Jm13-1.	-25

Location	Lo	c Oty	Loc Code	
MAT021		418		
123135		130		
124003		288		
	180	Each	457.0000	
				*

**

Self-Clinching Fastener

D3996-FE-832-EF

Location	Loc Oty	Loc Code
GA	457	
82502	46	
85727	34	
90233	377	

									DQA:	Date:	
NCR: Yes / No					WORK ORDER NON-C	ONFORM	ANCE / UPDATE				y.
									QA Closed:	Date:	
					DISPOSITION AGAIN		AINST DE	AINST DEPARTMENT/PROCESS			
Work Orde	er:	<u>.</u>		· · ·				,	1		
Down N	1-				Rework			sstube	D	Water Jet	Engineering
Part N					Scrap Use-as-is		ĕ ⊢	all Fab	1	d. Eng. Coor. re/Packaging	Quality Other
NCR N	lo				Work Order Update		~ 	posite	Rec/Stol	Supplier	Other
Well IV				 	Work Order opdate		Large rab com	iposite	l	Supplier	
Root				Descri	ption of work order update	Initial	Action		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Description		Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling	_										
Operator											
Material											
Setup											
Other											
Process			·				*				
Supplier											
Training											
Unapproved											
			• • • • • • • • • • • • • • • • • • • •			AULT CATE	GORY				
Landir	ng Gear			_	General				1		1
].	Bending			L	Bend	Grain		ļ	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	O/S	BOM/Route	⊢	Hardware		Over/Under		Temperature/Cure
]	Cracks				Broken/Damaged	⊢	ori Incomplete	<u> </u>	Part Incorre	·	Weld
ļ	Crushed/	Crimped.			Burrs	Instruct	ions Incomplete/Unclear	·	Part Lost/M	issing	Wrong Stock Pulled
ļ	Cuffs				Contamination	Mainte			Part Moved		
ļ	Heat Trea	at			Countersink	Mislabe	led	_	Positioned \	Wrong	-
	Inspection Strip in Tube				Cut Too Short	Misread			Power Loss,	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	94412	
Description: Wear Plate	Part Number:	D2348	
Inspection Dwg: D2348 Rev: C		Page 1 of 1	

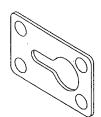
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0.329,,	_		✓	Ikmor
0.648	+/-0.010	6.651"	_		V	7.7.
0.795	+/-0.005	6.80.78	_		V	
2.046	+/-0.010	2.050'	_		V	
1.295	+/-0.010	1.298"	•		V	
Ø0.656	+0.005/-0.000	0.656"	_		V	
Ø0.290	+0.003/-0.000	0.291"	_		ν	
Ø0.250	+/-0.010	0.251"	-		V	
0.250	+/-0.010	0.251"	_		~	
0.648	+/-0.010	0.650	_		V	·
1.546	+/-0.005	1.549"	_		V	
·				· · · · · ·		
			OAS		<u>-</u> -L	

Measured by: $\mathcal{J}_{\mathcal{M}}$	Audited by:	09	Preliminary Approval:	
Date: 13-1-25	Date:	13-01-23	Date:	

Rev	Date	Change	Revised by Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM ₁ O
В	10.06.04	Dimensions update per Dwg Rev C	KJ &

ITEM	QTY -041	P/N	DESCRIPTION
11	Х	D2348	WEAR PLATE
2	1	D2348F	FLAT PATTERN
3	4	D3996-FE-832-EF	SELF-CLINCHING FASTENER



 $T^{N_{1},\ldots,N_{k}}$ UNCOPY, Prop SUBSTITUTE OF THE STATE OF NO 94412 MC5 12-12-17

DATE	09.1	0.01	T AEROSPACE PLED ON THE BORRES UNICATED TO ANY OTH T AEROSPACE LTD.	CONDITION THAT IS			
	DE APPR.		WEAR PLATE NT				
APPRO			TITLE		SCALE		
MFG. A			D2348		SHEET 1 OF :		
CHECK			DRAWING NO.		REV. C		
DRAWN 9		97	HAWKESBURY, ONTARIO, CANADA				
DESIGI	DESIGN BW		DART AEROS	PACEL	ח		
REV.	L		DESCRIPTION	BY	DATE		
В	CHANG	ED PEM INS	ERT TO 8-32	BW	95.02.20		
B1			804/316 MATERIAL	DS	00.03.07		
B2	+	ED BACK TO		DS	02.02.21		
С		W, ADD +0.0	CP	09.10.01			

D3996-FE-832-EF-SELF-CLINCHING FASTENER D2348F-

D2348 WEAR PLATE

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348" USING REMOVABLE TAG
7) WEIGHT: 0.01 lbs

- 2.046 Ø0.290^{+0.003} Ø0.656 0.250 4 PL 1.295 0.795Ø0.250 0.648 0.250 0.648 0.750 R0.13 TYP R0.125 TYP

D2348F FLAT PATTERN

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/IB/IC/II/IIB CLASS 2
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348F" USING REMOVABLE TAG

7

7) WEIGHT: 0.01 lbs

С

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN ar CHECKED DRAWING NO. REV. C MFG. APPR. D2348 SHEET 2 OF 2 APPROVED TITLE SCALE DE APPR. **WEAR PLATE** NTS COPYRIGHT © 1995 BY DART AEROSPACE LTD

PS DODARD TO PRIVATE ON THE STREAM OF THE COMPESS CHEMICAL THAT IT IS

NOT TO BE USED FOR MAY PLAYED BY COMPEDIATE ARROWS ALTER TO MY COMPET PERSON WITHOUT

WANTED PROJECTION FROM CARE ARROWS ALTER TO MY COMPET PERSON WITHOUT

WANTED PROJECTION FROM CARE ARROWS ALTER

WANTED PROJECTI DATE 09.10.01

3

2



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18989

Purchase Order Date 1/30/13 PO Print Date 2/01/13

Page Number 1 of 1

Order From:

VC-ATG001

A.T.G. INDUSTRIES INC. 731 INDUSTRIELLE ROAD ROCKLAND, ON K4K 1T2 CANADA

Contact Name

Vendor Phone

613-446-4544

Vendor Fax

613-446-4556

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms Currency Net 30 CAD

FOB

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Line Nbr Reference **Revision ID** Vendor Part Number Description/ Mfg ID

Req Date/ Taxable Unit of Measure

Req Qty/

Unit Price Ship Method

Extended

Price

D2348 WEARPLATE

2/08/13

80.00 FedEx PI collect

\$1.5000

\$120.00

Yes

Special In:

FINISH: BLACK ANODIZE PER MIL-A

TYPE I/IB/IC/II/IIB CLASS 2

PO Total:

\$120.00

CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required/YES NO

Change Nbr:

...nge Date:

2/01/13



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62191

Date: 01-Feb-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fav: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

FII. 013-032-32	00 Fax: 013-032-1185	P	n: 613-632-5200	Fax: 613-632-1185	
Terms		Ship Via			
<u> </u>			· · · · · · · · · · · · · · · · · · ·		
Quantity	Description				
80 ea	Part: WEARPLATE BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20130069	PO: PO18080	Rev:		
	Job: 20130069	PO: PO18989	Line:		
	Certificate of Cor A.T.G. Industries certifies that all items with all requirements, specifications and ISO 9001: 2008 REG ATG SALES-2010 TE DATE: DATE: RECEIVER SIGNATURE: CERTIFIED SIGNATURE:	in this shipment are in d drawings referenced GISTERED ERMS APPLY	in the purchase order.		
				· .	